

Tuesday, October 04, 2011 8:22:13 AM

Page 1



Accept

Revision ID:

Item Name: Window

Start Date: 9/30/2011 **Start Qty:** 6.00

Required Date: 10/14/2011 **Req'd Qty:** 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: M.C.5

Date: 11/10/04

Tooling:

Date:

Run

Start






QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3290	Rev C								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3290 <input type="checkbox"/> Dwg Rev: <u>C</u> <input type="checkbox"/> Prog Rev: <u>C</u> <input type="checkbox"/> 2- Deburr if necessary								
1/8 Poly									
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74540

Tuesday, October 04, 2011 8:22:13 AM



Page 2

Item ID: D3290-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 9/30/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Without removing protective skin <input type="checkbox"/> remove sharp edge by degurring.	0.00 0.00				x7			DL 11/10/13.
140 Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo 1-THERMOFORM as per Drawing D3290 and Folio FTA001 <input type="checkbox"/> Dwg. Rev. <u>C</u> <input type="checkbox"/> Folio Rev <u>B</u> <input type="checkbox"/> 2-Engrave part# & batch#, <input type="checkbox"/> (D3290-3)	0.00 0.00				x7			M. 11/10/13
150 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				x7			DL 11/10/13

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Work Order ID 74540

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Item ID: D3290-3

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Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 9/30/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170



Thermoform

HAND FINISHING THERMOFORMING

0.00

Memo

0.00

x7

OK
11/10/13

Thermoforming Machine

Water sand and buff to remove scratches if required

180



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/11/13

(x7)

Quality Control

190



Packaging

Identify as per dwg & Stock Location: Lunch

0.00

Memo

0.00

Room

x7

OK
11/11/14

Packaging

W/O:		WORK ORDER CHANGES						
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Work Order ID 74540

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Item ID: D3290-3

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Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 9/30/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC21 - Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/11/11
ME 11-11-04

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, October 04, 2011 8:22:18 AM

Page 1

Work Order ID: 74540

Parent Item: D3290-3

Parent Item Name: Window



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP A 04.08.18 New issue KJ/RF
 IPP B 06.05.09 Ecn 798 EC IPP Rev.
 C Removed QC8 Step 160 11/04/11 DL
 IPP C 07.05.29 Thermoform in-house DL
 IPP D 07.09.28 rev C dwg EC verified by: DD
 IPP E 07.11.28 Add --Hand finish deburring DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MACRLICS.125 Purchased

No

100

sf

105.0934

3

18.94737



1/8" Polycast II Sheet



B11-10-10

Location

Loc Qty

Loc Code

MAT

101.8467

117431

101.8467

MAT018

0.2467

117324

0.2467

MAT019

3

115338

3

117324

6

W/O:		WORK ORDER CHANGES					
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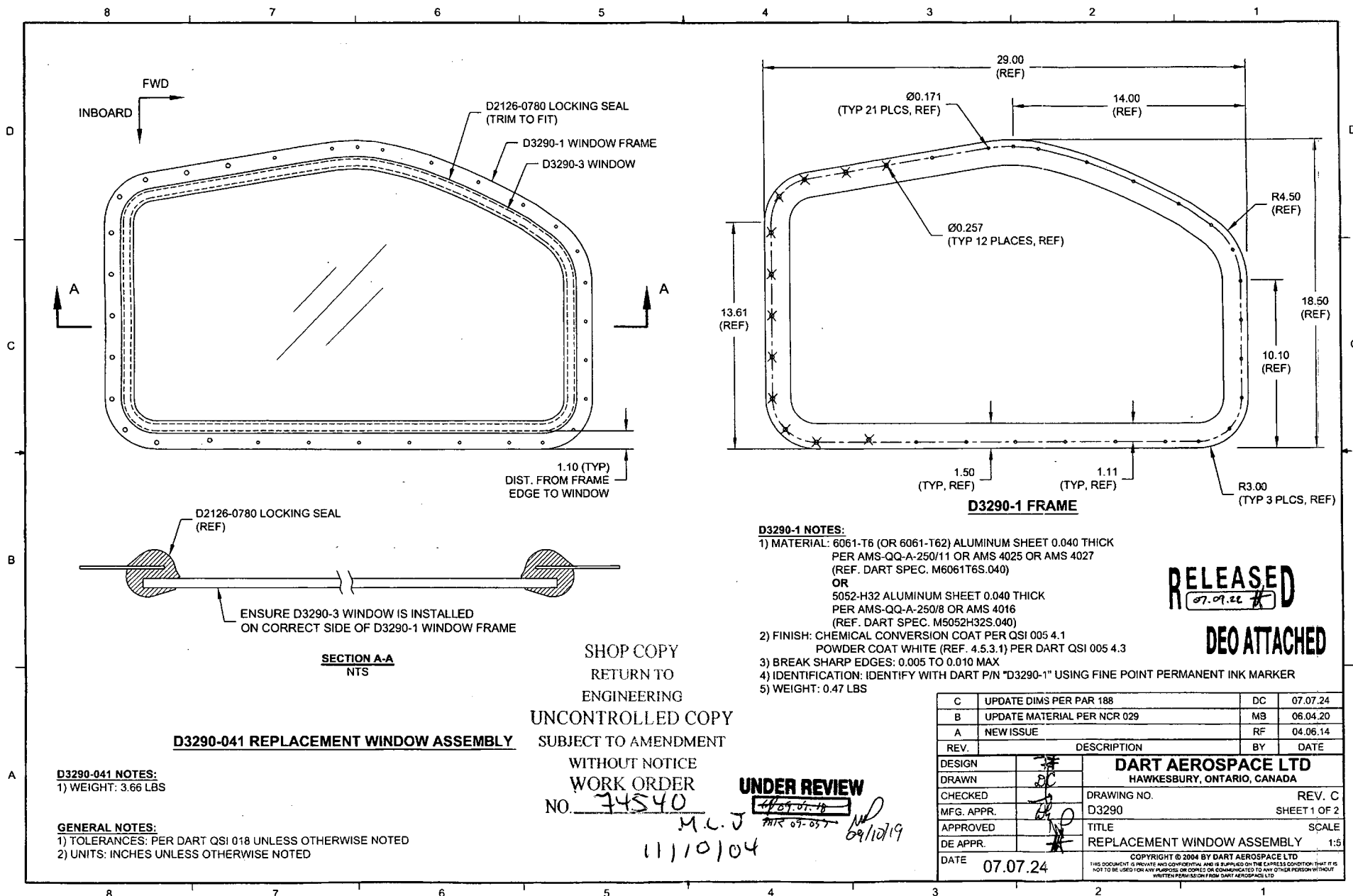
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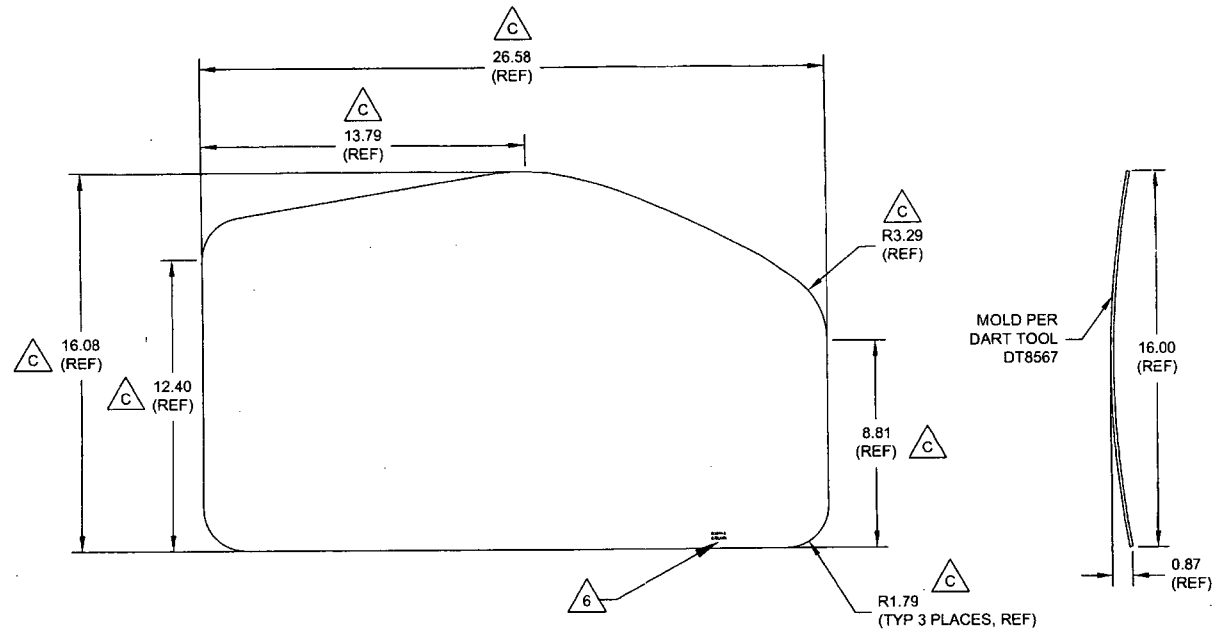
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74540



D3290-3 WINDOW



D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

UNDER REVIEW

DEO ATTACHED
RELEASED

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES						
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74540

DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>h</i>	MFG. APPR. <i>R</i>	APPROVED <i>MD</i>		DE APPR. <i>h</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009 -10- 09
WMP

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